

Monday, 12/17/2007 1:08:18 PM
Kim Johnston

Process Sheet

52

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L FWD X-TUBE
Job Number	: 36377	Part Number	: D206667103
Estimate Number	: 10553	Drawing Number	: D206-667-143 REV B
P.O. Number	:	Project Number	: N/A
This Issue	: 12/17/2007 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: 1 / Type : LANDING GEAR	Due Date	: 12/24/2007 Qty: 1 Um: Each
Previous Run	: 36376		
Written By	:		
Checked & Approved By	: <u>JA 07.12.17</u>		
Comment	: Est Rev E 05.09.01 Add holes for compatibility with Bell Skid tubes KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG002

JA 07.12.17

2.0	D6002115	Crosstube material
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
-----	-------------	-------------	-------

1 D6002-115

Crosstube

B23966

Check OD = 2.250"; ID = 1.750"

J.F. 07/12/21 ①

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA087

2-Turn first side as per Folio FA087

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

J.F. 07/12/21 ①

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/12/21 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-667-103 PAR #: NA Fault Category: Prod/Loading GEA NCR: Yes No DQA: D Date: 08/02/14
 QA: N/C Closed: 14 Date: 08/02/14

NCR: <u>36377</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.01.18	11	HEIGHT TALL BY 0.196" WIDTH NARROW BY 0.233"/0.22 (DIMS ARE FROM NOMINAL)	<u>GP</u> 08.01.18 per Q51042	Tube acceptable. Height dim would lower heli tail by 0.75" Drill holes @ 0.780 per Doug	<u>LEL</u> 8-13 8-1-23	<u>GP</u> 08.01.18 per Q51042	<u>GP</u> 08.01.21	

NOTE: Date & initial all entries

Date: Monday, 12/17/2007 1:08:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36377

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA087

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143

Inside of Cuff(Donot engrave on outside of tube)

J-F 07/12/21 ①

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J-F 07/12/21 ①

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.12.21 ⑦

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

AWM 07-12-27

1-Polish entire outside surface of crosstube

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

John 27 ①

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM 07-12-25

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-143 using CNC bender program 206L-fw and Folio FT017

EL 8-1-3

PTD on previous page

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36377

Part Number: D206667103

Job Number:



Seq #:

Machine Or Operation:

Description:

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

Sub 01-01 ①

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-143.

8-C/sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

*141
8-1-23
AUM 8-1-24*

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AUM 8-1-24

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/01/31 ④

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/31 ④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36377

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 5590 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

08/02/04

①

18.0

PACKAGING 1 -

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

08/02/04

①

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

08/02/04

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

RT 08-02-04

RT 08-02-04

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

08/02/05

①

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total : 1.2138 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 6.94") Abrasion Strip

35900

RT 08-02-05

23.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate

36064

RT 08-02-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36377

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

34077

RT 08-02-04

25.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support

34062

RT 08-02-05

26.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet

105057

RT 08-02-04

27.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

103478

RT 08-02-09

28.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. Note: (2) Aft holes should be facing up.

2-Install supports and clamps as per Dwg D4206-667-143. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

} RT 08-02-05

RT 08-02-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36377

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/06 (TL)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M105408

PU

32.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M105940

PU

33.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part number

10 AN5-7A

Description Batch

Bolt M106167

PU

34.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

4 AN5-30A

Description Batch

Bolt M105144

M105144

PU

35.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part number

18 AN960JD516

Description Batch

Washer M106167

PU 08/26/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/17/2007 1:08:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 36377

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/02/08

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103

Location:

PPP Rev:

B

JS

8/2/8

SD

(1x)

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.02.13
JA

Job Completion



mi 2008/2/11

(1)

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36377
Description: Crosstube Assembly (206L High Fwd)	Part Number:	D206-667-143
Inspection Dwg: D206-667-143 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

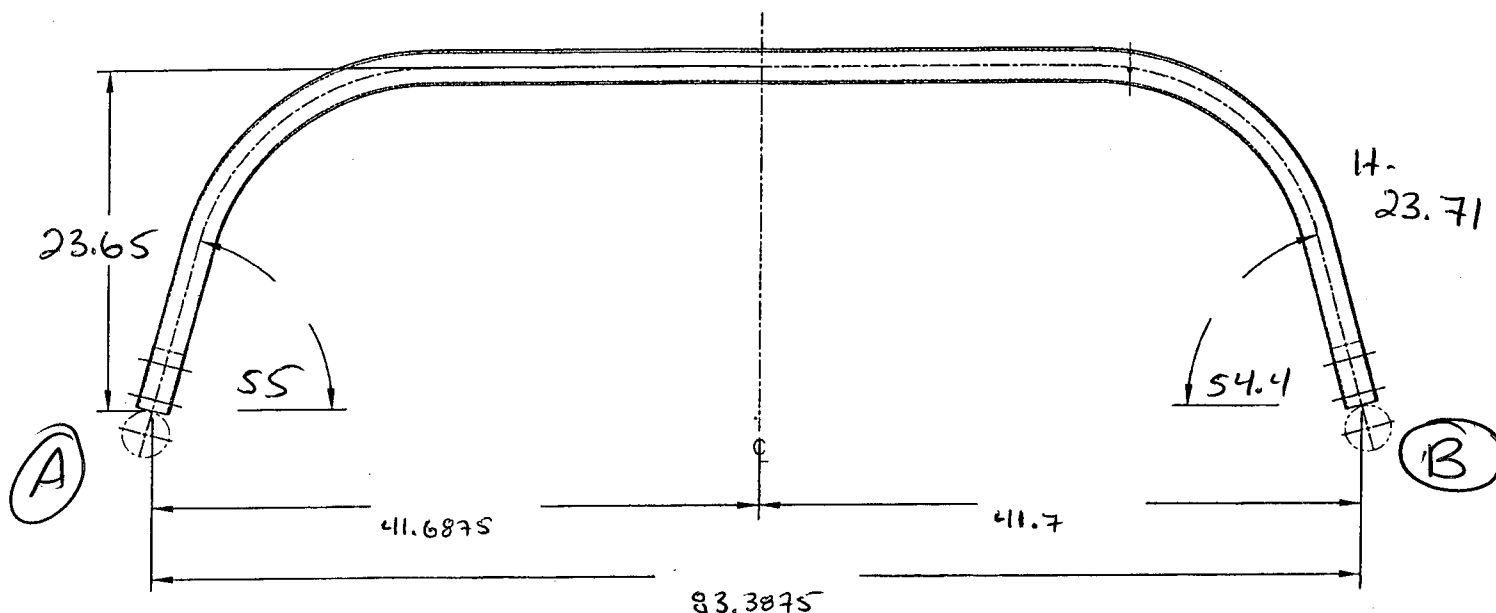
	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.245"	✓			
	1.982	+0.005/-0.000	1.986"	✓			
	2.019	+0.005/-0.000	2.024"	✓			
	2.058	+0.005/-0.000	2.063"	✓			
	2.097	+0.005/-0.000	2.101"	✓			
	2.136	+0.005/-0.000	2.139"	✓			
	2.176	+0.005/-0.000	2.179"	✓			
	2.201	+0.005/-0.000	2.204"	✓			
	0.125	+/-0.010	.125"	✓			
	0.400 x 30°	+/-0.010	.400 x 30°	✓			
	R0.063	+/-0.010	R0.063"	✓			
	R0.500	+/-0.010	R0.500"	✓			
	4.438	+/-0.030	4.438"	✓			
SIDE B	104.98	+/-0.020	104.990"	✓			
	2.240	+0.005/-0.000	2.244"	✓			
	1.982	+0.005/-0.000	1.987"	✓			
	2.019	+0.005/-0.000	2.024"	✓			
	2.058	+0.005/-0.000	2.063"	✓			
	2.097	+0.005/-0.000	2.101"	✓			
	2.136	+0.005/-0.000	2.138"	✓			
	2.176	+0.005/-0.000	2.180"	✓			
	2.201	+0.005/-0.000	2.204"	✓			
	0.125	+/-0.010	.125"	✓			
	0.400 x 30°	+/-0.010	.400 x 30°	✓			
	R0.063	+/-0.010	R0.063"	✓			
	R0.500	+/-0.010	R0.500"	✓			
	4.438	+/-0.030	4.437"	✓			

Measured by: J.F.	Audited by: SD	Prototype Approval:	N/A
Date: 07/12/21	Date: 07.12.21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.05.06	New Issue (P/O D206-667-103)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	

DART AEROSPACE LTD		Work Order:	36377
Description: Crosstube High Fwd (206L)		Part Number:	D206-667-103
Inspection Dwg: D206-667-143 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments
height is slightly uneven, but high & narrow.
See PTO 2 sequence 11.0

QC15 Inspection	
Date	08-01-21

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-143	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH FWD)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.07.26 H**UNDER REVIEW**

05.08.10 PH

re-draw detail F
PH

07.05.02

Qty	Part Number	Description
X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
1	D6002-115	CROSSTUBE
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

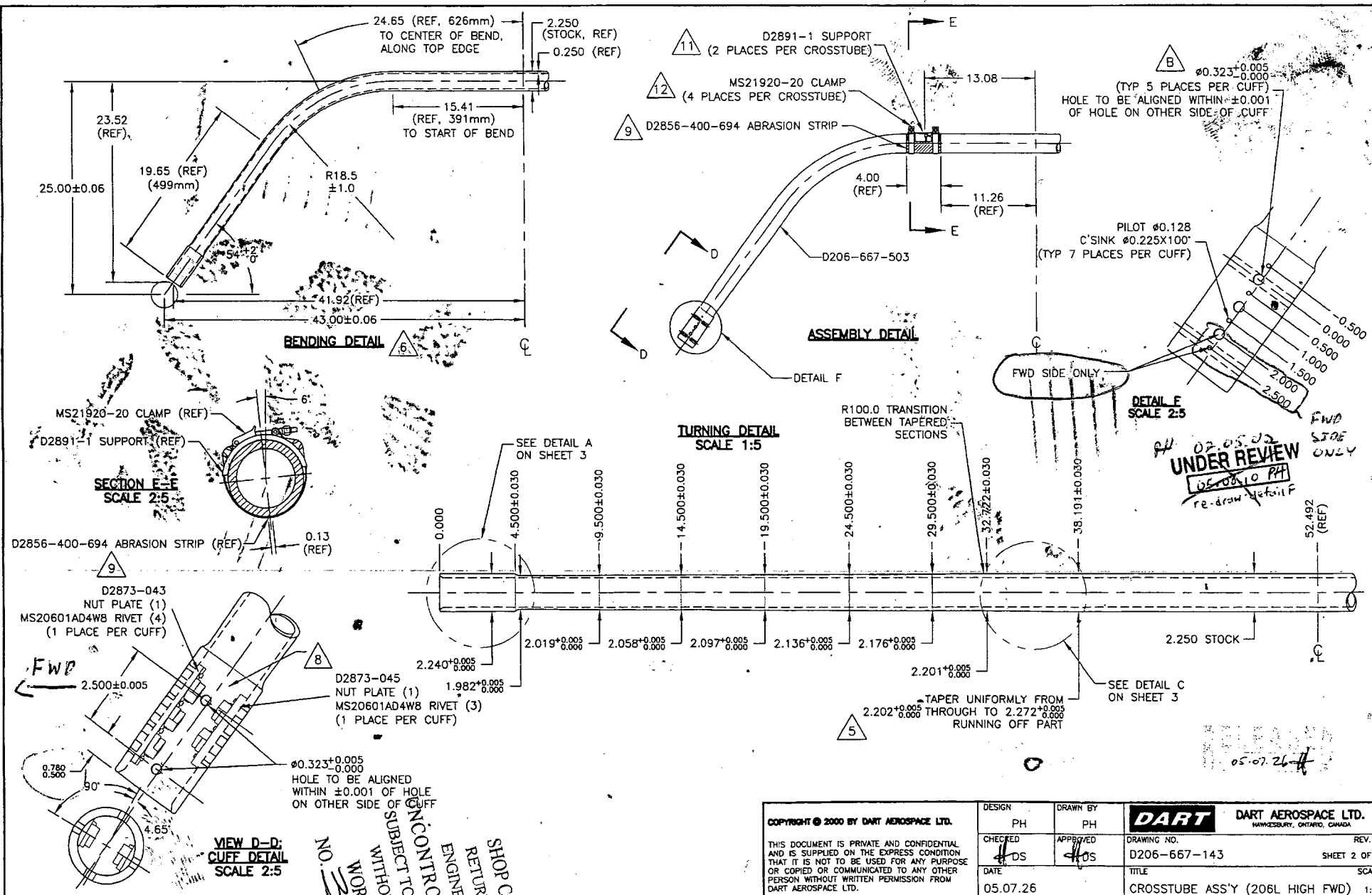
WITHOUT NOTICE

WORK ORDER

NO. 36377

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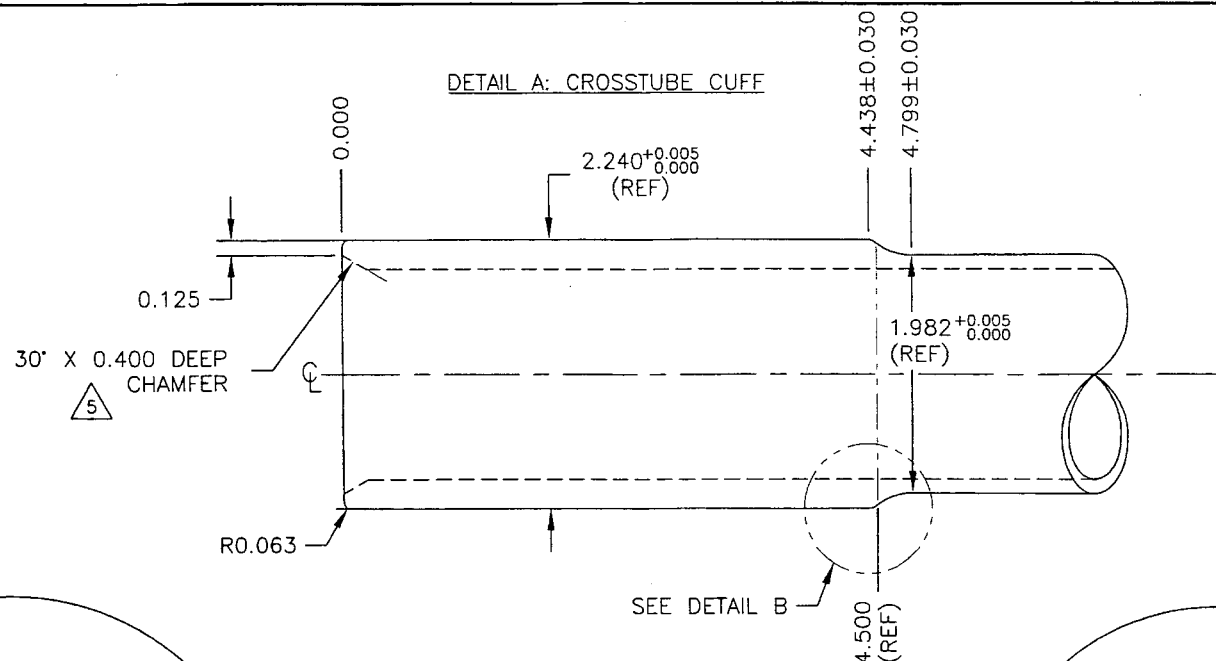
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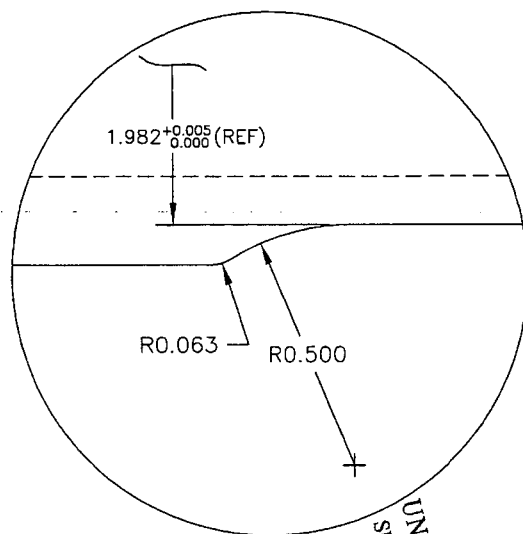
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DESIGN	PH	DRAWN BY	PH	DART	DART AEROSPACE LTD.
CHECKED	DS	APPROVED	DS	DRAWING NO.	D206-667-143
DATE	05.07.26	TITLE	CROSSTUBE ASS'Y (206L HIGH FWD)	REV. B	SHEET 2 OF 3
		SCALE	1:10		

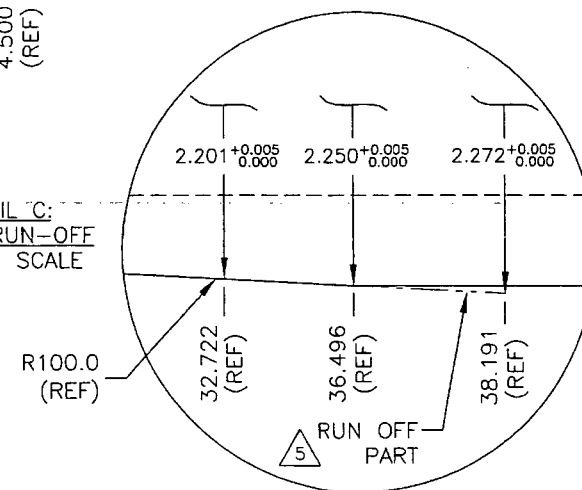


UNDER REVIEW
 06.07.26 PH
 redraw detail F
 PH 07.05.02



DETAIL B: CUFF
 TRANSITION
 SCALE 4:1

DETAIL C:
 TAPER RUN-OFF
 NOT TO SCALE



NO. 32377
 WORK ORDER
 WITHOUT NOTICE
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 ENGINEERING
 RETURN TO
 SHOP COPY

COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. HAMMERSBURY, ONTARIO, CANADA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-143	REV. B SHEET 3 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH FWD)		SCALE 1:1	



LIQUID PENETRANT TEST REPORT

P- 09829

PAGE 1 OF 1

TIME AM ☐ PM ☐

CLIENT

Dot Aerospace

DATE

Feb 01 2008

ATTENTION

Linda Lacelle

ACUREN JOB NO.

ADDRESS

1270 Aberdeen St, Hawkesbury
ONT.

PO/VO No.

WORK LOCATION

Hawkesbury

ACCEPTANCE STD.

ASTM E1654-03

REV./DATE

2005

PROJECT

Job # 34637, 36377, 36769, 36771

ITEM(S) EXAMINED

212 X-TUBE, LOW NARROW FWD - 206L FWD X-TUBE, 412 X-TUBE LOW
NARROW AFT, 412 X-TUBE, LOW NARROW AFT

JOB DESCRIPTION

PROCEDURE No. LT-0002 REV./DATE

TECHNIQUE No. LT-0002 REV./DATE

PART NO.

D212664147, D206667103, D41264201

THICKNESS

SCOPE

WET FLOUORESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100%
OF EXTERNAL SURFACE

TEST DETAILS

METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	MAGNAPLUX		BLACK LIGHT S/N	3178	<input checked="" type="checkbox"/> OUTPUT > 1000 μ W/cm ²
PENETRANT	2L67	MINIMUM DWELL TIME	40-45 MIN.	LIGHTING EQUIP.	<input checked="" type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input checked="" type="checkbox"/> OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER	H2O	MINIMUM DRY TIME	> 10 MIN.	OTHER	
DEVELOPER		MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N	
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY	CAL DUE DATE	MAR 08

TEST SURFACE

SURFACE CONDITION	<input checked="" type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F	<input type="checkbox"/> -4°C/ 20°F TO 10°C/ 50°F	<input checked="" type="checkbox"/> 10°C/ 50°F TO 52°C/ 125°F	<input type="checkbox"/> > 52°C/ 125°F	

RESULTS- (☐ METRIC ☐ IMPERIAL)

ITEM	COMMENTS	ACCEPT	REJECT
34637	: ACCEPTABLE		
36377	: ACCEPTABLE		
36769	: ACCEPTABLE		
36771	: ACCEPTABLE		

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE

Linda Lacelle

TECHNICIAN (SIGNATURE):

FREDERICK CHAGNOL

NAME (PRINT):

CGSB LEVEL

II

SNT LEVEL

CGSB REG. No

10560

CGSB LEVEL

SNT LEVEL

CGSB REG. No

DTR #

REPORT

REVIEWED BY:

NAME

INITIALS

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

PT Sept 2005